

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018686**Date Inspected:** 20-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

**OBG Trial Assembly Area**

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW repair welding of several temporary longitudinal alignment plate welds located outside PCMK OBG 11DE/11EE, side plate to bottom plate, holdback weld area, north (counterweight) side. See photo below. Welder was identified as 040724. QC was identified as ZPMC CWI Shi Lei (QC1). Welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-4G(4F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-CWR2139 presented to this QA Inspector and verbally identified by QC1. QC1 also informed this QA Inspector that the above noted repairs were in response to ZPMC visual testing. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Cai Hai Zhou.

ABF personnel performing magnetic particle testing at the 11CE/11DE transverse joint, side plate, north (crossbeam) side. A ZPMC worker was working with him and grinding when instructed by the ABF representative.

ZPMC personnel match drilling deck plate U-rib inner splice plates through previously drilled holes in the U-ribs in 11DE at the 11CE/11DE transverse joint, using magnetically-held drill presses.

Heavy Dock

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# WELDING INSPECTION REPORT

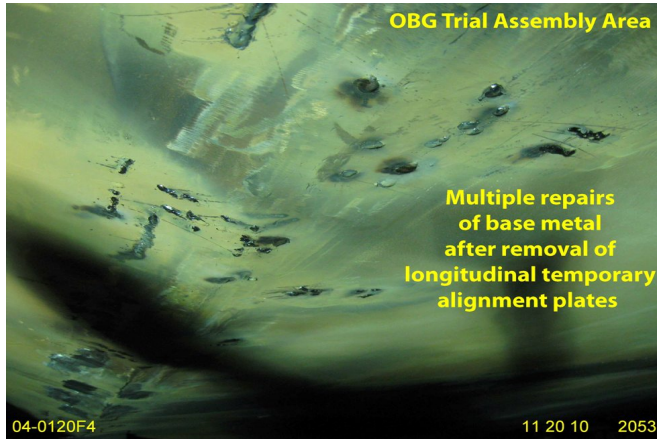
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This QA Inspector randomly observed the following on the Heavy Dock:

All 4 towers, lift 4 were positioned on a base pedestal at end of the Heavy Dock. All four towers, lift 5 were positioned on top of the respective lift 4. No work was being performed on the Heavy Dock and no floating crane was in the area of the Heavy Dock.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

As noted above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet, George
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon, Albert
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QA Reviewer
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